<u>SPECIFICATION</u>

Please replace the paragraph [0004] with the following replacement paragraph:

[0004]   As the rollers 15/16 are drawing the webs 11 and 12 under the seaming iron, the web section on which pouch seams have previously been formed is passed into an accumulator portion of the machine. The accumulator is the portion of the machine between rollers 15/16 and roller 23. As the web 110 is fed into the accumulator, gravity causes a dancer roller 24 to move downward and accommodate the web being fed in. A high limit sensor, such as a photo-detector 32 and light source 34, detects a shortage of web material in the accumulator section. The signal from the high limit sensor may be sent to a controller for one of the adjacent processes to increase the amount of web material in the accumulator section. For example, the second controller 29 may respond to the high limit ~~photo-detector 32~~ sensor 32, 34 by slowing a transverse web cutter 10 to increase the amount of web material in the accumulator section. Similarly, a low limit sensor, such as a photo-detector 33 and light source 35, detects an excess of web material in the accumulator section. The signal from the low limit sensor may be sent to a controller for one of the adjacent processes to reduce the amount of web material in the accumulator section. For example, the second controller 29 may respond to the low limit ~~photo-detector 33~~ sensor 33, 35 by speeding up the transverse web cutter 10 to reduce the amount of web material in the accumulator section.

Please replace paragraph [0027] with the following replacement paragraph:

[0027]   In the web transport system of the exemplary transverse web cutter 10, the web 110 is clamped by two clamps 39 that engage the web 110 just ahead and just behind the line where the web is to be severed to release a finished product 111. In this web cutter 10, a second

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motor 36 operates the clamps 39. The second motor rotates a cam 40 which lifts the support bars 41 by means of a push rod and cam follower 42. The support bars may be spring loaded to urge the support bars downward. When the support bars 41 are permitted to lower by rotation of the cam 40, the clamps 39 engage the web 110. The web transport system provides a synchronization signal at a known point in each cutting cycle. The synchronization signal may be derived from any source that provides a reasonably consistent point of reference for the time when the web will be stopped and ready for cutting. The synchronization signal may be provided at some point in the cutting cycle before the time when the web should be cut. It will be appreciated that regardless of where in the cutting cycle the synchronization signal occurs, the synchronization signal will always precede a cutting operation by no more than the length of one cutting cycle.

Please replace paragraph [0029] with the following replacement paragraph:

[0029]   The operations of the web cutter 10 are synchronized by a control system 29. Sensors [[32, 33]] 32, 34 and 33, 35 may be provided to detect the presence of the dancer roll 24, wherein the sensors may include photo-detectors 32, 33 that sense a light source 34, 35. In other embodiments other types of sensors may be used to sense the position of the dancer roll. The control system 29 receives a signal, such as the signal from the accumulator system sensors 32, 34, and 33, 35 to control the speed of the web cutter 10. It will be appreciated that the control system 29 may be integrated with other control systems 21 in a single unit. It will be appreciated that the long term average speed (length of web processed in a given time) of all the web processes must be the same. The accumulator only accommodates instantaneous differences in speed between adjacent processes. When the dancer roll 24 rises above the upper sensor 32, 34

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the cutter may be signaled to reduce its speed. Conversely, when the dancer roll 24 falls below the lower sensor 33, 35 the cutter may be signaled to increase its speed. In other systems, the speed of the web cutter 10 may be set to a particular value and the speed of preceding operations may be adjusted to match the speed of the web cutter.

Please replace paragraph [0035] with the following replacement paragraph:

[0035]   The control system may maintain a delay value which is the length of time after the ~~reference~~ synchronization signal when the actuating signal is provided. The control system may adjust the timing by increasing or decreasing the delay value to advance or retard the actuating signal relative to the synchronization signal. If the control system 29 adjusts the actuating ~~signals~~ signal to cause the cutting knife 27 to reach the predetermined position based on time, the control system may determine the time when the cutting knife should reach the predetermined position based on the speed of the transverse web cutter 10. The delay value may be increased if the cutoff knife arrives at the predetermined position too soon after the synchronization signal or if the speed of the web cutter is reduced. The delay value may be decreased if the cutoff knife arrives at the predetermined position too long after the synchronization signal of if the speed of the web cutter is increased.

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